Work Order ID 71508

Tuesday, July 05, 2011 10:16:03 AM

Item ID: D3438-042 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Step Weldment Assembly

Start Date: 7/5/2011 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 7/15/2011 **Req'd Qty:** 2.00 **Customer:**

Reference:

Approvals: **Process Plan:** W **Date:** **Tooling:** **Date:** **Run Start** **Stop**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3438	Rev A								
100	Large Fab	0.00							
Large Fab									
Large Fab	**Memo**	0.00							
	1-Cut D2244 to 79.63" at 34° as per Dwg D3438 2-Deburr ends 3-Weld one cap, LUG PLATES &MOUNTING ANGLE as per Dwg D3438 using DT8343 4-Grind								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	**Memo**	0.00							
Quality Control									

11-07-05 2 Ø

A 11-08-11 2 Ø

*2 Ø 8E11/08/11

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
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NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00				2			
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 **Memo**	0.00 0.00				x2	0		
140 QC Quality Control	QC3- Inspect Part Finish **Memo**	0.00 0.00				2			

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NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Large Fab	0.00							
Large Fab	**Memo**	0.00	AL 7/11.08.12			2	ϕ		
Large Fab	Weld last cap per dwg D3438 & grind flush								
160	QC10- Inspect visual per QSI004- ground welds	0.00							
QC	**Memo**	0.00	5 wlos 15						
Quality Control									
170	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00	5 wlos 15			(+2)			
Quality Control									

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QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	**Memo**	0.00							
Powder Coating	1-Touch up alodine START TIME: 7:50 OVEN TEMPERATURE: 320°F FINISH TIME: 8:20								
190	HandFinishing	0.00							
HandFinish	**Memo**	0.00							
Hand Finishing	Wing Walk as per Dwg 3438 and QSI 005 4.4 Mask off 0.5 each side of D2561 lugs								
200	QC3- Inspect Part Finish	0.00							
QC	**Memo**	0.00							
Quality Control									

M118439 m-h 11/08/15 2x Ø m-h 11/08/16

M118313 2x Ø m-h 11/08/16

11/8/17 sl ☺

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W/O:		WORK ORDER CHANGES					
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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location:_____	0.00	71507			11/8/17			
Packaging	**Memo**	0.00							
Packaging									
220	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00				11/8/24			
Quality Control									

MF
11-08-18

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Tuesday, July 05, 2011 10:15:59 AM

Work Order ID: 71508

Parent Item: D3438-042

Parent Item Name: Step Weldment Assembly

Start Date: 7/5/2011 **Required Date:** 7/15/2011

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP A[ ]05.05.18[ ]New Issue[ ]KJ/JLM[ ]

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2244-116 Step Extrusion		Manufactured	No			100	Each	123.0000	1	2	2	11.07.05	
				Location		**Loc Qty**		**Loc Code**					
				HALL		93							
					60307	93							
				WA		30							
					60307	30					2		
D2561 Lug		Manufactured	No			100	Each	11.0000	2	4	4	11.07.05	
				Location		**Loc Qty**		**Loc Code**					
				WA015		11							
					66813	5							
					68981	6					4		
D2564 Mounting Angle		Manufactured	No			110	Each	28.0000	2	4	4	11.07.05	
				Location		**Loc Qty**		**Loc Code**					
				WA		28							
					69286	28					4		

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Tuesday, July 05, 2011 10:16:00 AM

Work Order ID: 71508

Parent Item: D3438-042

Parent Item Name: Step Weldment Assembly

Start Date: 7/5/2011 **Required Date:** 7/15/2011

Start Qty: 2.00 **Required Qty:** 2.00

D2673-34	Manufactured	No		100	Each	99.0000	2	4

End Plate

Location	Loc Qty	Loc Code
WA	76	
69534	76	
WA015	23	
59690	23	

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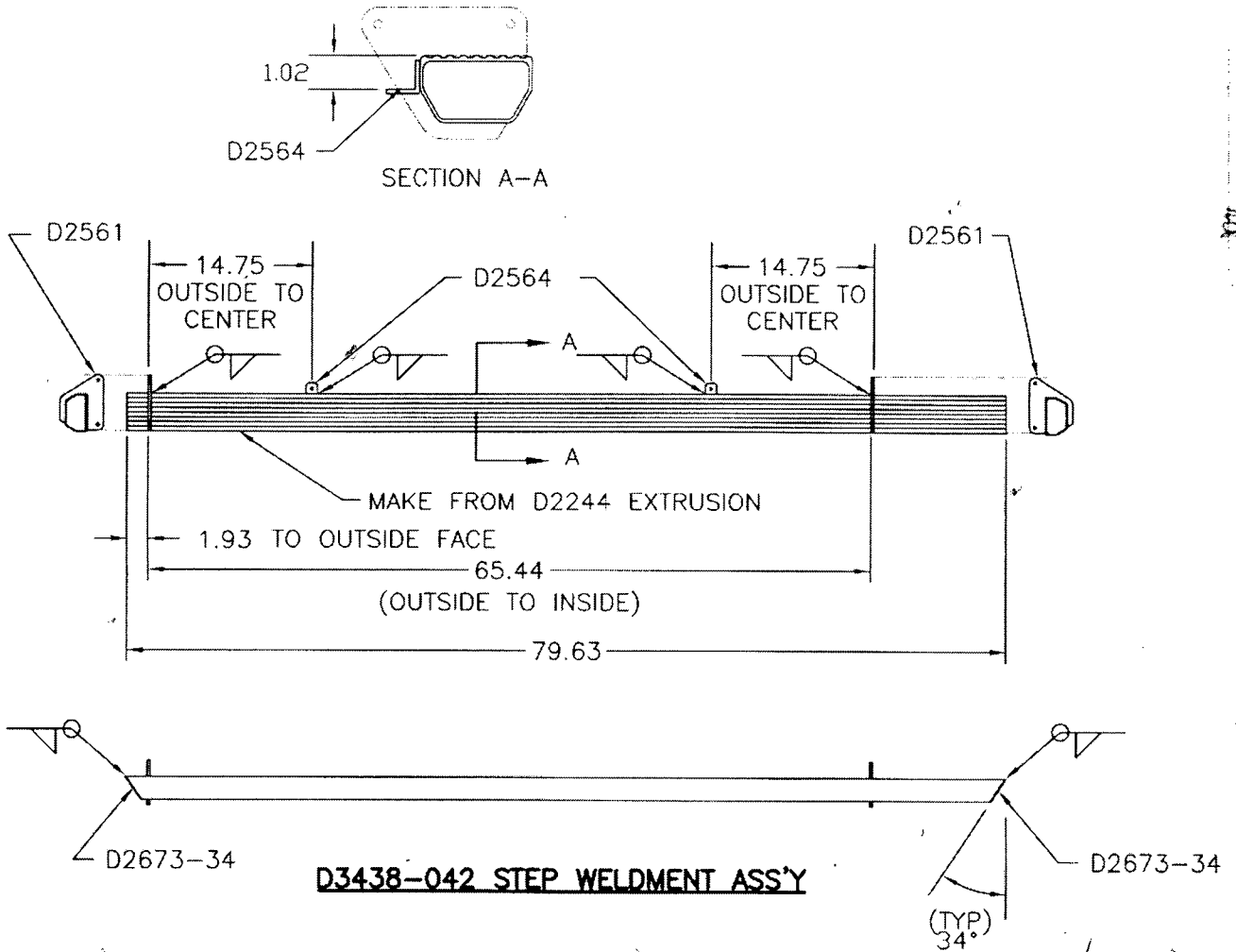

D3438-042 STEP WELDMENT ASS'Y

NOTES:

1) WELD PER DART QSI 004
2) TOLERANCES ARE PER DART QSI 018
3) ALL DIMENSIONS ARE IN INCHES
4) FINISH: ACID ETCH & ALODINE PER QSI 005 4.1, POWDER COAT WHITE PER QSI 005 4.3.5.1
   WING WALK TOP PER QSI 005 4.4, MASK OFF 0.5 EACH SIDE OF D2561 LUGS

w/o 71508

RELEASED
05.05.27

REV	DATE	DESCRIPTION
A	05.05.09	NEW ISSUE

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
RF	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3438 REV. A
DATE 05.05.09		TITLE STEP WELDMENT ASSEMBLY SHEET 1 OF 1
		SCALE 1:1